

Work Order ID 83113

Friday, April 13, 2012 8:23:21 AM

83113

Page 1

Item ID: D3547-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 4/12/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 4/26/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 120412 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					<u>14</u>			
D3547	Rev A								

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3547 Dwg Rev: A Prog Rev: A

6061.125

****Ensure Grain Direction is Correct****2-Deburr if necessary

12

12-5-29

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-5-29

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

14

12-5-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 4/12/2012

Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/26/2012

Req'd Qty: 10.00

10

Customer:

Reference:

Run Start

NR1

Stop

NR2

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

0.00

0.00

0.00

170

QC3- Inspect Part Finish

170

QC

Quality Control

Memo

180

Identify as per dwg & Stock Location:

180

Packaging

Packaging

Memo

14x

✓

M-F
12/06/01

14x 6 12/06/01

~~12/06/01~~
SP 126-5.
MW 12/06/01

M 21134

9:30
320°F
10:00

W/O:		WORK ORDER CHANGES					
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Work Order ID 83113***83113***

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Friday, April 13, 2012 8:23:21 AM

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Revision ID:

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Item Name: Bracket

Start Date: 4/12/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 10.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/6/47

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, April 13, 2012 8:23:33 AM

Page 1

Work Order ID: 83113

83113

Parent Item: D3547-1

D3547-1

Parent Item Name: Bracket

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No				sf	61.2900		0.557895			
M6061T6S 125										**			
6061-T6 .125 Sheet												B12-5-29	

Location

Loc Qty

Loc Code

MAT021

61.29

113608

46.69

118217

0.09

119513

10.8

120218

3.71

121473

121473

(14)

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DART AEROSPACE LTD		Work Order: 83113
Description: Bracket		Part Number: D3547-1
Inspection Dwg: D3547	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.313	+/-0.010	.313	2		V RBL	
0.913	+/-0.010	.914	2		V	
2.054	+/-0.010	2.056	2		V	
2.38	+/-0.030	2.380	2		V	
0.438	+/-0.010	.438	2		V	
2.813	+/-0.010	2.814	2		V	
0.575	+/-0.010	.577	2		V	
1.100	+/-0.010	1.098	2		V	
1.625	+/-0.010	1.623	2		V	
2.150	+/-0.010	2.147	2		V	
2.675	+/-0.010	2.675	2		V	
3.25	+/-0.030	3.252	2		V	
Ø0.172	+0.005/-0.001	.176	2		V	
Ø0.323	+0.006/-0.001	.328	2		V	
0.125	+/-0.010	.127	2		V	

Measured by: RB
Date: 12-5-29

Audited by: [Signature]
Date: 12-05-29

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM [Signature]	RB

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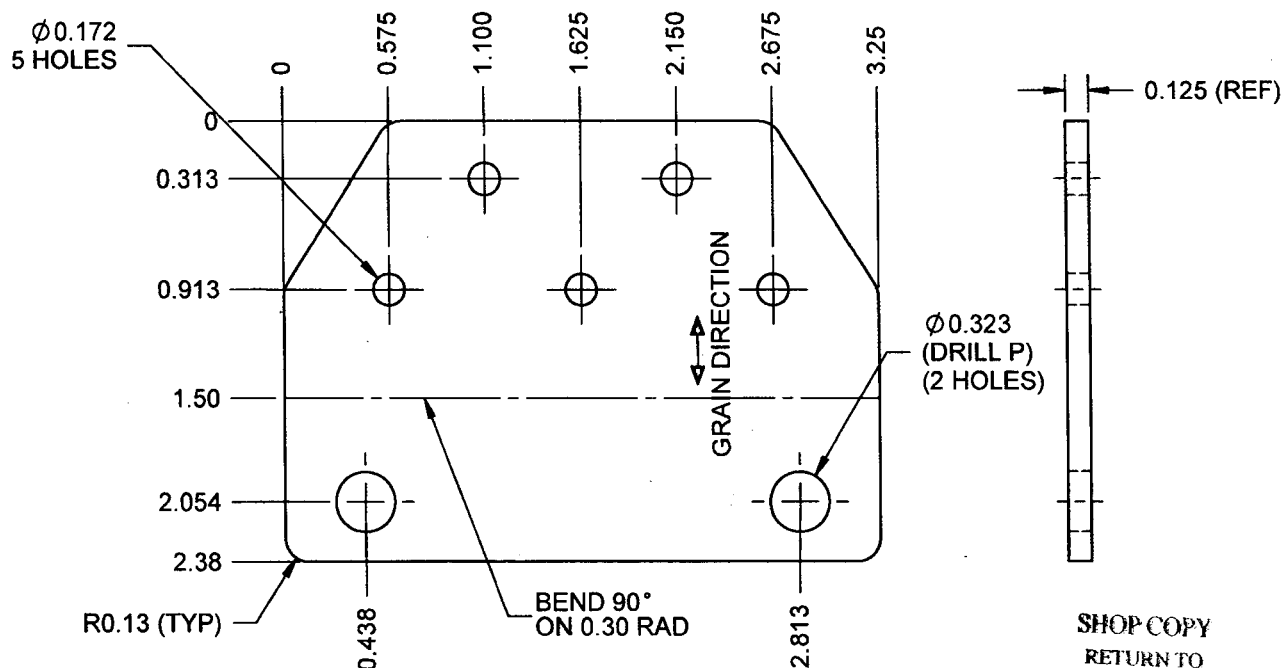
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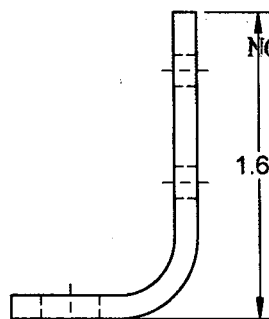
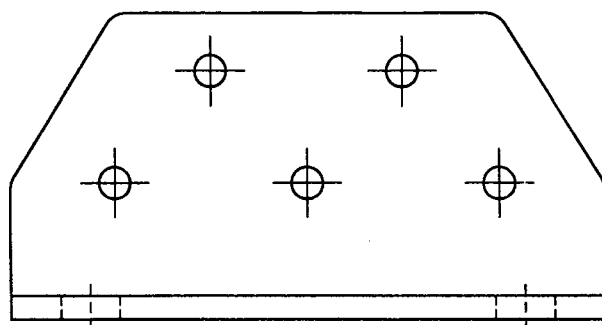


DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3547	REV. A SHEET 1 OF 1
DATE 06.10.06	TITLE BRACKET SCALE 1:1		
REV A	DATE 06.10.06	DESCRIPTION NEW ISSUE	

RELEASED
06.10.13



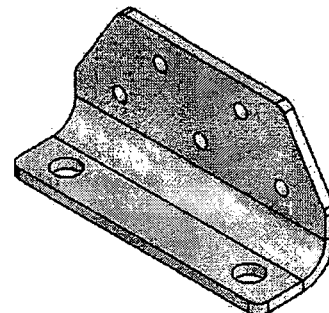
D3547-1F FLAT PATTERN



D3547-1 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3547-1 USING FINE POINT PERMANENT INK MARKER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *83113*
112-04-12

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Dart Aerospace Ltd

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